



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2281

Job Sheet 172489



Part No: D2281

Job Qty: 50 ea

Part Name: Jack Saddle



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/20/18

Job Tracking No:

Due Date: 3/5/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV G IPP Rev:A Removed from 9 Digit 05-12-02 JLM IPP: rev B

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	50 Ea		3/3/18	0.00	0.00	Start Up Waterjet		pc 18/02/20
100	Waterjet	50 pcs		3/3/18	0.00	2.62	Waterjet1		pc 18/02/20
120	QC	50 pcs		3/3/18	0.00	0.00	QC8		38
140	Brake NC	50 pcs		3/5/18	0.01	1.26	Brake NC 1		28 FB
150	QC	50 pcs		3/5/18	0.00	0.00	QC5		38
160	Packaging	50 pcs		3/5/18	0.00	0.00	Packaging3		9-00 E/
170	QC21-SA	50 Ea		3/5/18	0.00	0.00	QC21		cm 18/03/01

Part Op 100 - 1-Cut as per Dwg Dwg Rev: G Prog Rev: G 2-Deburr if necessary

Descriptions: 140 - Form as per D2281 using D2281-T2

160 - LOCATION : WA001

DAS

21

9-00

MAR 05 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S14GA	304SS sheet .080	6.2500 sf (.125 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S14GA	6	55	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Jack Saddle	4.468Inches ± 0.010	4.478 4.458		
2	Jack Saddle	4.114Inches ± 0.010	4.124 4.104		
3	Jack Saddle	2.933Inches ± 0.010	2.943 2.923		
4	Jack Saddle	1.535Inches ± 0.010	1.545 1.525		
5	Jack Saddle	0.354Inches ± 0.010	0.364 0.344		
6	Jack Saddle	0.354Inches ± 0.010	0.364 0.344		



Container No: S044131



Part: D2281

Job No: 172489

Serial No/Batch: S044131

Revision: D2281

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/21/18

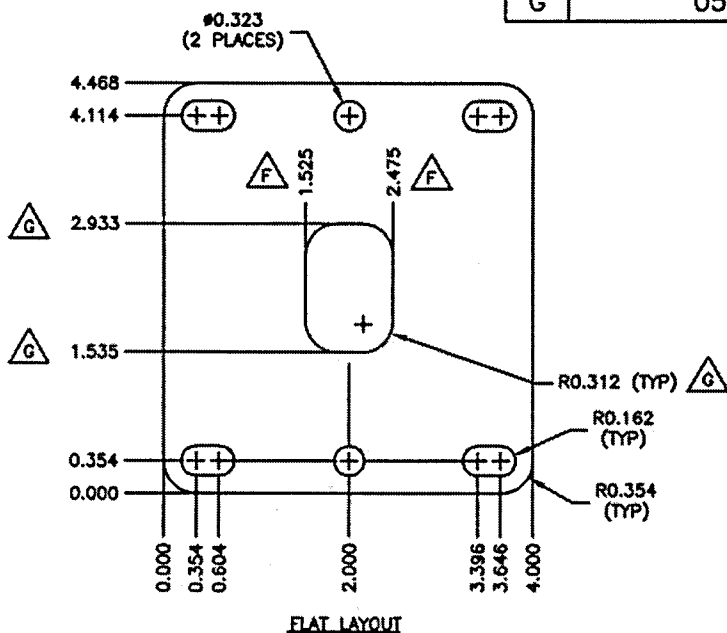
7	Jack Saddle	0.604Inches $\pm$ 0.010	0.614	0.594
8	Jack Saddle	2.000Inches $\pm$ 0.010	2.010	1.990
9	Jack Saddle	3.396Inches $\pm$ 0.010	3.406	3.386
10	Jack Saddle	3.646Inches $\pm$ 0.010	3.656	3.636
11	Jack Saddle	4.000Inches $\pm$ 0.010	4.010	3.990
12	Jack Saddle	1.525Inches $\pm$ 0.010	1.535	1.515
13	Jack Saddle	2.475Inches $\pm$ 0.010	2.485	2.465
14	Jack Saddle	0.323Inches $\pm$ 0.006	0.329	0.322
15	Jack Saddle	0.080Inches $\pm$ 0.010	0.090	0.070

Diameter

Plex 2/20/18 8:57 AM Dart.lajeunesse.marie

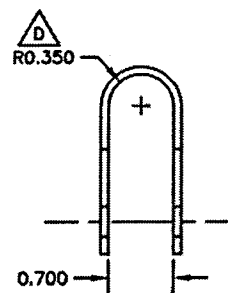
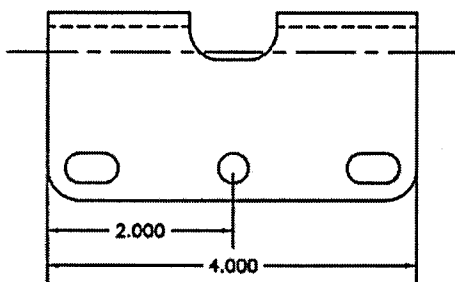
DART

DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2281	REV. G SHEET 1 OF 1
DATE 05.06.07	TITLE JACK SADDLE		SCALE 1:2
A	94.10.14	NEW ISSUE	
B	94.10.18	DIMENSION WAS 2.878	
C	94.11.04	ADD TOOLING NOTCH	
D	98.03.27	R0.350 WAS R0.280	
E	04.11.18	REMOVE TOOLING NOTCHES	
F	05.03.16	REDESIGN FLAT PATTERN	
G	05.06.07	REDESIGN FLAT PATTERN	

RELEASED
[Signature]
05/08/11

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 172489

FEB 20 2018

**D2281 JACK SADDLE**

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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